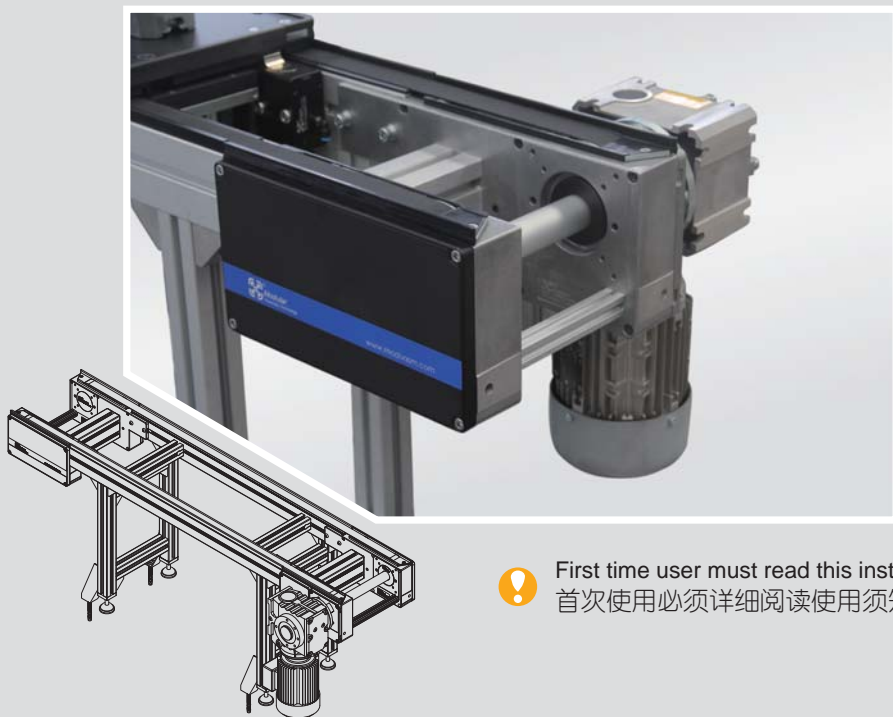



PTS1/H Pallet Conveyors

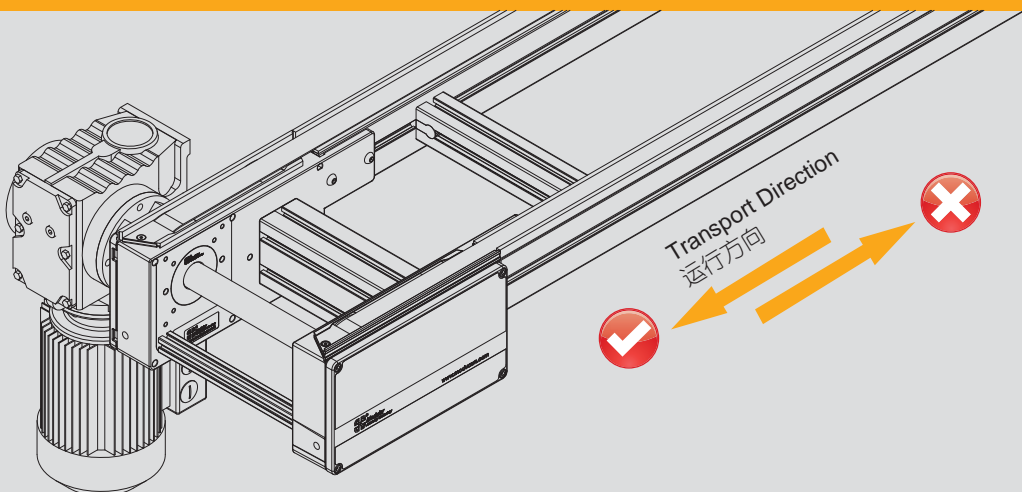
Instruction & Maintenance Manual

PTS1/H 托盘输送线安装使用维护手册



 First time user must read this instruction
首次使用必须详细阅读使用须知

大连美德乐工业组装技术有限公司
Modular Assembly Technology Co.,Ltd.



Initial Operation Notice 首次使用须知

Reverse direction operation of PTS1/H is not permissible, which might be damaged and cannot be fixed. First operation should be controlled within 2 seconds, please check if the conveying direction of chain is right.

PTS1/H 输送机禁止反向运转，否则会对设备造成不可逆的损坏，首次运行需短促启动系统（最长2秒），检查链条运行方向是否正确。

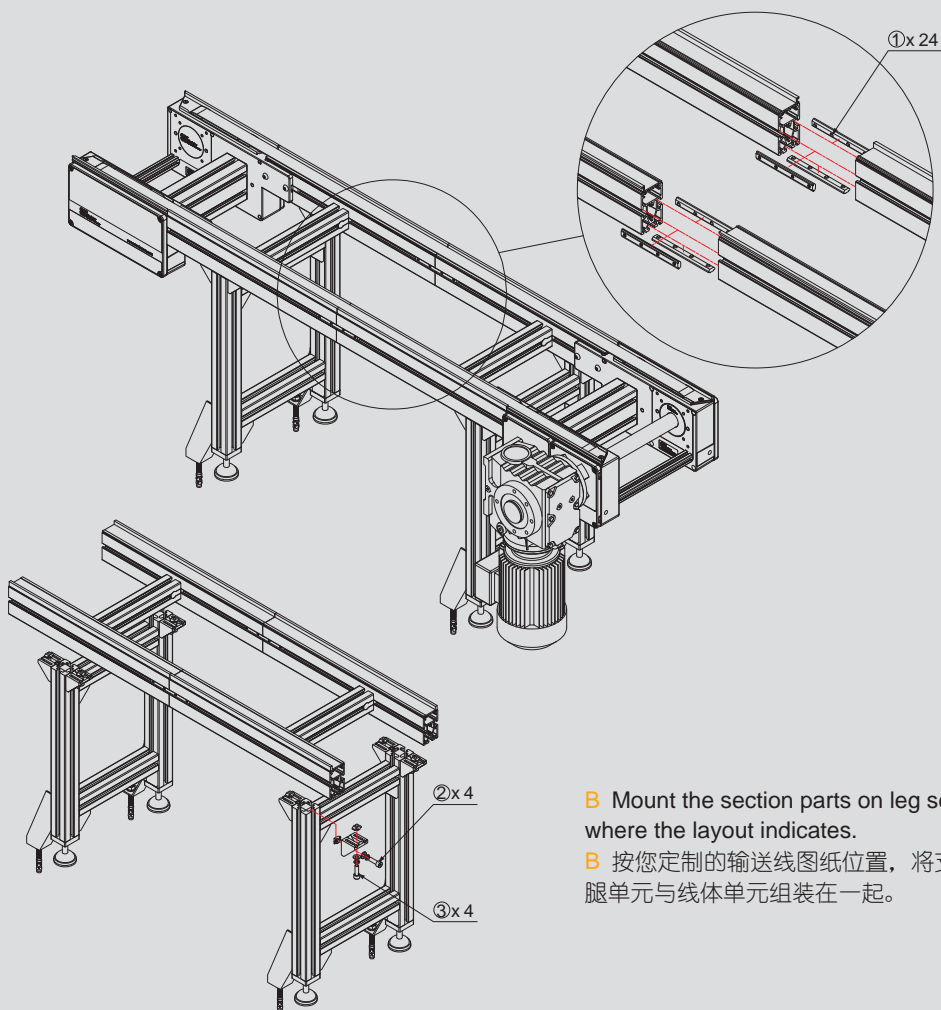
Overload circuit breaker must be installed(it will be provided by customers), to avoid the motor damage by overcurrent.

电机必须额外安装过载断路器（客户自备），可避免电流过载导致电机损坏。

If your shipment of conveyor is in parts, please follow the below assembly instruction.
如果您收到的是产品单元或部件，请按照以下说明进行安装

A Join the the section parts together according to the drawing if the conveyor is made of two or more sections parts.

A 若您的输送机线体单元由两部分或多部分组成，需按本图将线体组装为一体。



B Mount the section parts on leg sets where the layout indicates.

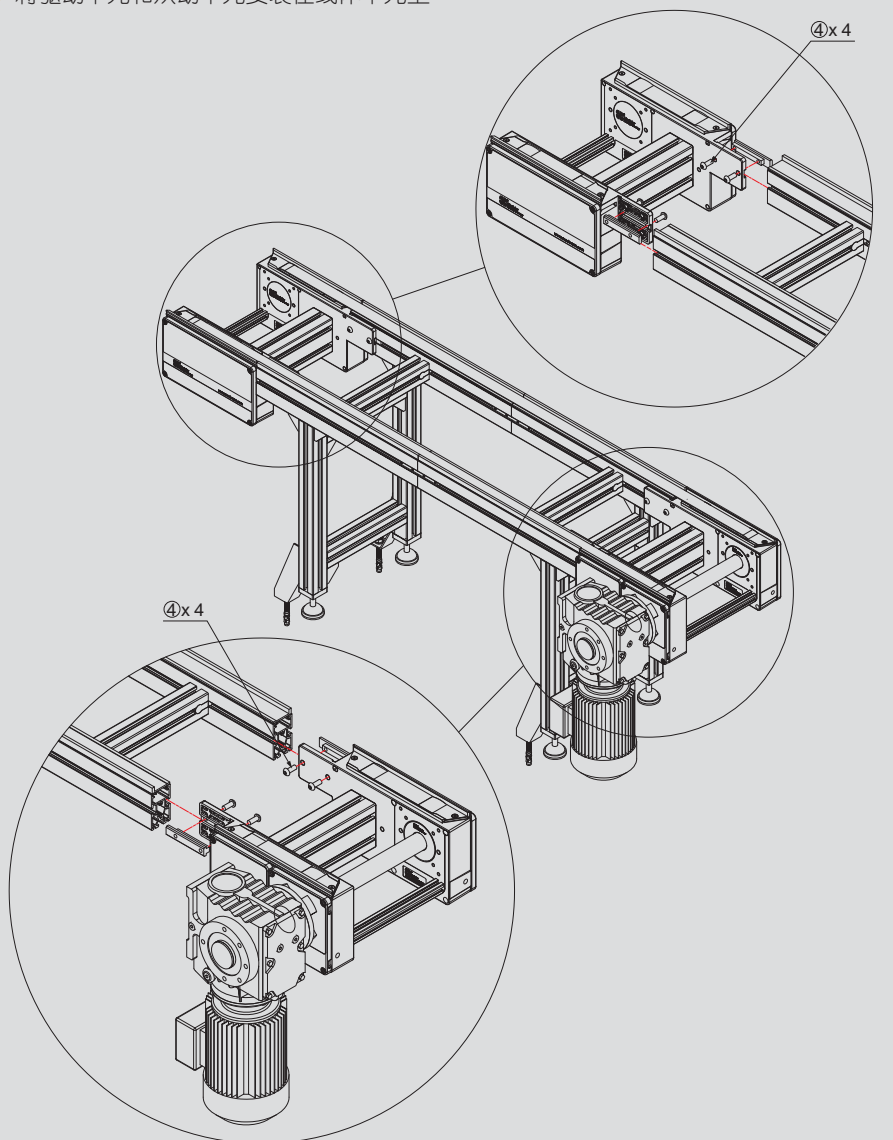
B 按您定制的输送线图纸位置，将支腿单元与线体单元组装在一起。

① M8X10
④ 6 Nm

② M8X25
⑥ 13 Nm

③ M8X20
⑥ 13 Nm

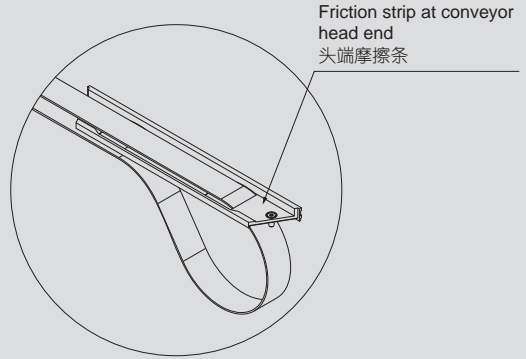
- C Attach the drive unit and driven unit to the conveyor section.
- C 将驱动单元和从动单元安装在线体单元上



④ M8X20
⑤ 8 Nm

D The base belt shipped together with the conveyor encircles the friction strip as indicated. Normally, the basebelt is installed on the conveyor.

D 随设备出厂的片基带，已与头端摩擦条穿连在一起，穿过方式如图所示。通常情况下，出厂之前，片基带已经与线体组装完毕。

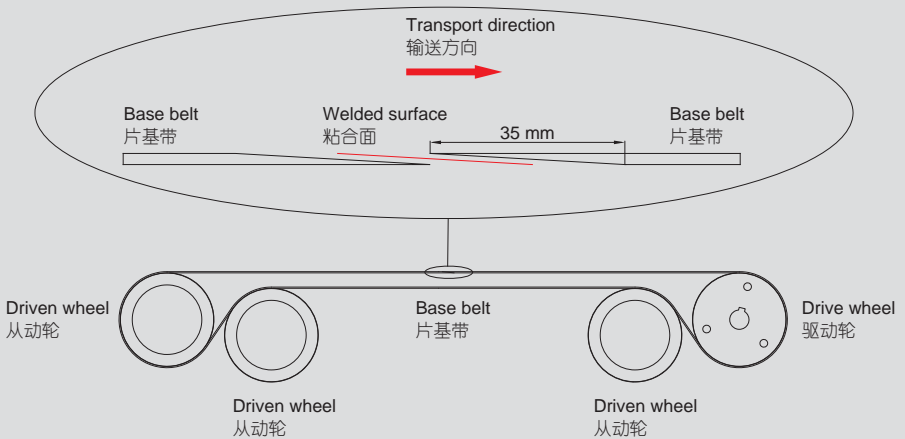


E If the base belt need to be installed by customer, please follow the steps below:

E 若需自行安装片基带，请务必按照以下步骤进行组装：

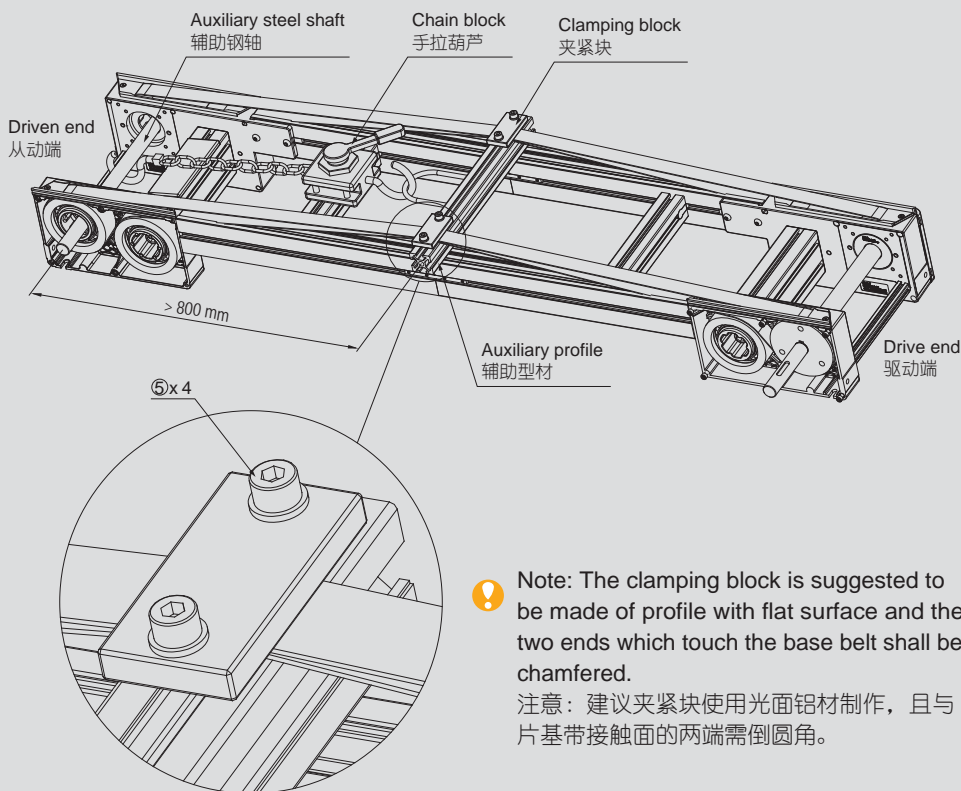
1 Firstly, the upper welded surface and lower welded surface of the base belt need to be confirmed according to transport direction. Then the base belt shall be installed on the drive wheel at the drive end according to the following figure.

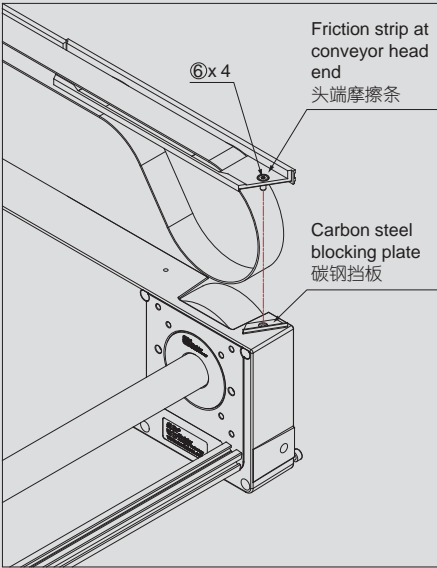
1 首先根据输送方向确认片基带粘合面的上下层关系，然后按照图示将片基带安装在驱动端的驱动轮上。



2 Pull up the two base belts and fix the base belts on the auxiliary profile with the clamping blocks. Connect the chain block with auxiliary profile on one end and auxiliary steel shaft on the other end. Tighten the chain block to have the clamping block and auxiliary profile moving to the driven end. Then install the base belt on the driven wheel.

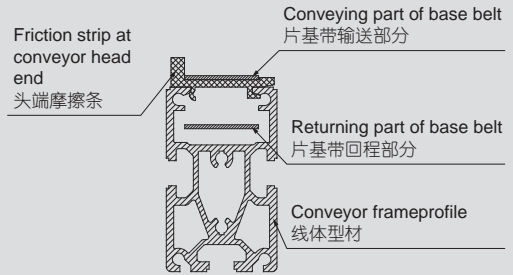
2 将两条片基带拉起，用夹紧块将片基带固定在一根辅助型材上。将手拉葫芦两端分别与辅助型材、辅助钢轴连接，上紧手拉葫芦，让夹紧块与辅助型材整体向从动端移动，将片基带安装在从动轮的从动轮上。






3 As shown on the left figure, fix the head end friction strip and blocking plate onto the drive/driven unit casing, disconnect the chain block and clamping block and the base belt will be tensioned. The section of the conveyor line is as the following figure after assembly.

3 如左图所示，将头端摩擦条与碳钢挡板固定在驱动/从动单元壳体上，松开手拉葫芦与夹紧块，片基带自动张紧。组装完成后，线体断面如下图所示。

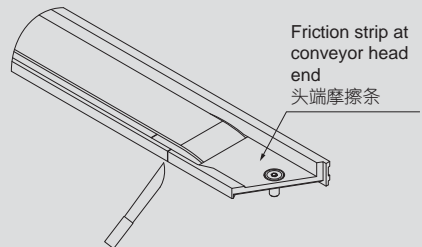


 **Note:** Please contact us if the base belt need to be replaced due to wear or other reason and we will assign professional operator to provide the service for you. (The base belt replacement need special tool and trained operator. It is suggested not to replace the belt for unnecessary case, which will also protect your warranty right.)

注意：如果片基带因磨损或其他原因需要替换，请联系我司，我们将派遣专业人员为您服务。（因片基带的安装对工具和人员的专业性要求都比较高，所以非必要情况下，不建议自行更换，也避免影响您的保修权益。）

F If the base belt need to be replaced urgently, please cut the friction strip at the position pointed by the knife first. Then the existing base belt can be removed. After new base belt is replaced according to step E, the cutting shall be fixed with instant glue (such as 502 etc.).

F 若急需替换，请在取下片基带前，务必注意先在图示中刀尖所指位置将头端摩擦条切开，旧片基带方可取出，按照步骤“E”更换新片基带后，需要将切口用瞬间固化粘合剂（如502等）粘接牢固。



Maintenance

维护和保养

Modular Pallet conveyors are designed and produced for a long life cycle, but correct maintenances are required timely. These include the cleaning, replacement of damaged parts and preventive measures. The measures should be scheduled daily, weekly, monthly and quarterly.

Modular 托盘输送设备按较长的使用年限设计并生产，然而它也需要被适时和正确的维护。包括按时清洁和及时更换损坏的零部件。并做预防性的维护工作，包括下文的日维护，周维护，月维护和季度维护。

Daily Maintenance

日维护


Before running the conveyor each day, please check and remove small parts or fragments falling on the conveyor line; the foreign matters on the conveying medium might damage the equipment. 每日开机前，检查和移除任何掉落在输送线上的小零件和碎片等异物；掉落于输送介质上的异物有可能损坏设备。

Weekly Maintenance

周维护

Clean the dust on the surface each week. Check that if there is any debris or fragment embedded underneath the pallets or conveyor line and remove them.

每周清洁设备表面污垢。检查是否有异物或碎片嵌入托盘底部和输送线的输送介质中。

 **Note:** lubricant or cleanser that might corrode metal, UHMWPE, Nylon and rubber etc can not be used.

注意：不能使用能够腐蚀金属、超高分子量聚乙烯、尼龙、橡胶等材料的润滑脂或者清洁剂。

Monthly Maintenance

月维护

Check the fasteners that may loose and tighten them with wrench each month.

每月检查可能松弛的紧固件，并使用对应的扳手紧固。

Quarterly Maintenance

季度维护

Check whether there is circuit breakage and focus on the wiring location.

检查电路是否有破损情况，重点在各种接线位置。

Regular Troubleshooting

常见故障及处理方法

1. Noise from drive unit or driven unit: check if the bearing is lack of lubricating grease. The driven wheel unit shall be changed if necessary.
 2. Overheated motor: check if the equipment is overloaded, or the motor loses on phase due to loose motor wire.
1. 驱动单元或从动单元异响：检查轴承是否缺少润滑脂，必要时请整体更换从动轮组。
 2. 电机过热：检查设备是否超载，或者电机接线松动导致电源缺相。

Wear Parts Care

易损件的维护

1. Check the friction strip at the conveyor head end on regular basis (suggest on weekly basis). Please replace the spare as appropriate if there is local wear, aging etc.
 2. Check the base belt on regular basis (suggest on weekly basis), including if there is abnormal wear on belt surface, there is abnormal opening on edge of base belt, there is abnormal wave impacted mark on the whole base belt. Please replace the spare as appropriate.
 3. Check the side friction strip on regular basis(suggest on weekly basis). Please replace the spare as appropriate if there is local wear.
1. 定期检视头端磨擦条的磨损情况（建议按周维护频次），如发现局部发生加速磨损、老化等现象，则视具体情况更换备件。
 2. 定期检视尼龙片基带（建议按周维护频次），包括带面是否有异常磨损，片基带边缘是否有异常开口，片基带整体是否有异常波浪状冲击痕迹，视具体情况更换备件。
 3. 定期检视线体侧边摩擦条（建议按周维护频次），如发现局部发生加速磨损情况，视具体情况更换备件。

Modular Conveyor System

模块化输送系统

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